



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB KIT 407M-03
Job Sheet 171576



S052166

DAS
13
9-89

MAR 16 2018

Part No: RB KIT 407M-03

Rev. C

Job Qty: 3 pcs

Part Name: Gauge Pin

DAS



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/5/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/9/18	2/9/18	0.00	0.00	Start Up Container		AT 18/03/21
100	Outsource	6 pcs	2/9/18	2/9/18	0.00	0.00	Outsource16		AT 18/03/21
110	Packaging	6 pcs	2/9/18	2/9/18	0.00	0.00	Packaging2		AT 18/03/21
120	QC	6 pcs	2/9/18	2/9/18	0.00	0.00	QC6		38
130	Packaging	6 pcs	2/9/18	2/9/18	0.00	0.00	Packaging3		MAR 22 2018
140	QC	6 pcs	2/9/18	2/9/18	0.00	0.00	QC21		MAR 22 2018

Part Op 100 - 1-Issue P/O to KG Grinding; P/O 039202 (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3-Descriptions: Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
GM36-144	Gauge Pin 0.04Ø	6 (1 ea) 3	100-Outsource	S044656 S053361

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Outsource	GM36-144	6 3	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

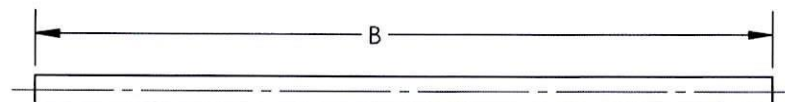
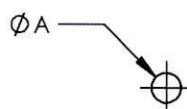
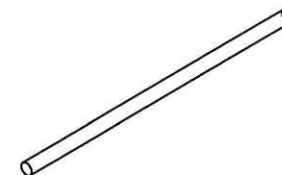
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																									
Description Work Order Deviation																																																													
Change No: Operation: Revision: Serial No/Batch: PART NO: RB KIT 407M-03 S052166 Packaging Mtg Date: 03/16/18 Job No: 171576 Gauge Pin .0400" dia. 																																																													
Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																													
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment</td> <td style="width:5%;">☐</td> <td style="width:15%;">No Re-</td> <td style="width:5%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operat</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/t</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Te</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Inforr</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> <tr> <td colspan="4" style="text-align: right;">OTHER : _____</td> </tr> </tbody> </table>						Root Cause				Environment	☐	No Re-	☐	Design	☐	Operat	☐	Doc/Data	☐	Offset/t	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Te	☐	Internal Transport	☐	Poor Inforr	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	OTHER : _____			
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0085	-01 THRU -31 ADDED GUAGE PIN DIMENSIONS TABLE.	4/6/2017	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171576 MJS

1802-05



GUAGE PIN DIMENSIONS		
PART NUMBER	ØA	B
-01	(Ø.0240)	1"
-03	(Ø.0400)	1"
-05	(Ø.0540)	1"
-07	(Ø.0600)	1"
-09	(Ø.0800)	1"
-11	(Ø.0960)	1"
-13	(Ø.1080)	1"
-15	(Ø.1200)	1"
-17	(Ø.1440)	1"
-19	(Ø.1440)	1/4"
-21	(Ø.1600)	1"
-23	(Ø.1600)	1/4"
-25	(Ø.1728)	1"
-27	(Ø.1728)	1/4"
-29	(Ø.1800)	1"
-31	(Ø.1920)	1"

(-01 THRU -31)
GUAGE PIN

DART AEROSPACE	
TITLE SPLINE MEASURING KIT ASSY	
DWG NO. RB KIT 407M-01 THRU -31	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT BLACK	.XXX ± .005 FRACTIONS ± 1/8
FINISH AS PLATED	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 407
SCALE 4:1	DATE 12/7/2016
SHEET 2 OF 5	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039202**

Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: PO039202

PO Date: 3/5/18

Due Date: 3/14/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

REVISED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170734	RBST4241-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs AT	\$12.00/pcs	\$72.00
2	173095	RBST2854-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 4 pcs	Firmed	3/14/18	26 pcs	0 pcs 26x	26 pcs	\$12.00/pcs	\$312.00
3	170733	RBST1016-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs	\$12.00/pcs	\$72.00
4	171045	RBST1007-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 3 pcs	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs	\$12.00/pcs	\$72.00
5	RB KIT 407M-09		Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs 3x	3 pcs	\$12.00/pcs	\$36.00

3/16/2018

PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
13	171576	RB KIT 407M-03	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
						/	3x			
14	171575	RB KIT 407M-01	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
						/	3x			
15	171592	RB KIT 407M-31	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
						/	3x			
Grand Total:										\$960.00
Order Notes						rec'd AT 18/03/21				
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 3/16/18 8:50 AM dart.lavoie.chantal

AFFUTAGE K.G. INC.
K.G. GRINDING INC.

40 ans
Depuis 1975

**11455 Ave. Philippe Panneton
Montréal, Québec
Canada, H1E 4M1
Tél. : 514-323-0192
Fax : 514-323-6631**

Distributeur d'outils de coupe & Affutage sur mesure

Distributor of cutting tools & Custom tooling

BON DE LIVRAISON
DELIVERY SLIP

DATE: MAR-14-2018

DART AEROSPACE

73008

P.O. # 39202

QTÉ	LIVRÉE	B/O	DESCRIPTION	PRIX UNITAIRE	TOTAL
3	(30)	-	RIB KIT 407M-03		
3	(30)	-	" " - 01 "		
3	(3)	-	" " - 31		
				SOUS-TOTAL	
				TPS	
				TVQ	
				TOTAL:	

REÇU EN BONNE CONDITION / RECEIVED IN GOOD ORDER

www.kggrinding.com • sales@kggrinding.com